

Work Order ID 86237

86237

Page 1

June-25-12 10:32:29 AM

Item ID: D3537-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 25/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								
100		0.00							
100	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
304 .063	1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
120	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

24 0 Jm 12-7-4

24 0 Jm 12-7-4

5/26/10

countes
x24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158	0.00 0.00				<u>24</u>			<i>SB</i> <i>12/07/12</i>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D3429	0.00 0.00		<i>Scholar</i>		<i>Contes</i> <u><i>24</i></u>			
150 *150* Large Fab Large Fab Large Fab	Large Fab Memo Qty Description Batch A/R 2059B Hardcoat <i>M122279</i> Weld hardcoat as per Dwg D3437	0.00 0.00				<i>24</i>			<i>12-07-11</i> <i>1BL</i>

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Required Date: 10/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M121279

3200F

900

counts
220

24X

12/07/16

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

24x 4 12/07/11

24X 12/07/16

12/17/18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-25-12 10:32:33 AM

Page 1

Work Order ID: 86237

86237

Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

1.5746

0.149

3.136842

M304S16GA

**

3.25 S.F.

Jm 12-7-4

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

1.574633

121889

1.574633

122245

122245

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

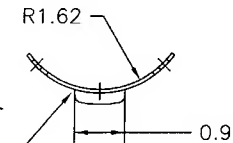
WITHOUT NOTICE

WORK ORDER

NO 86237

12/06/25

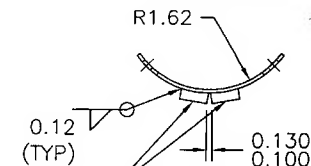
SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

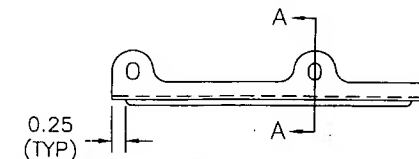
OK 11/11/15

SECTION B-B

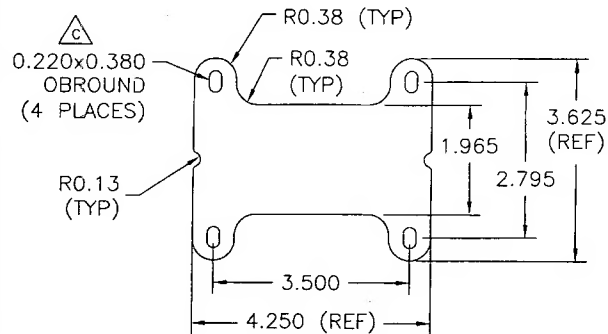


D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

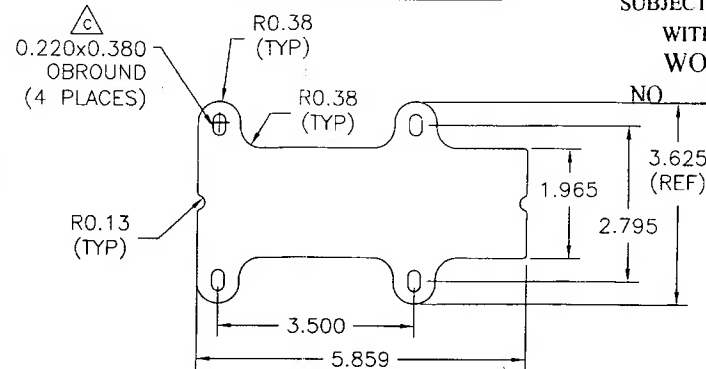
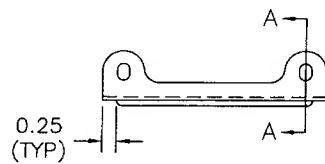
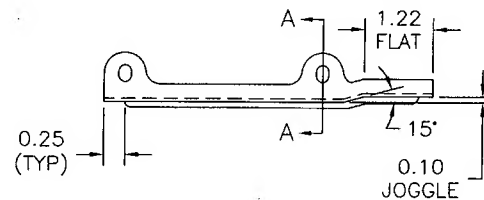
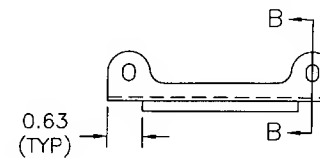
RELEASED
07.05.08 AH
PER ECU
962

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)

D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)

D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD

DART AEROSPACE USA, INC.
FORT WALLOO, VA

SHEET 1 OF 1

SCALE 1:2

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